

Work Order ID 74455

Wednesday, October 05, 2011 11:16:10 AM



Page 1

Item ID: D3806-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

B

100

0.00



Cold Saw

0.00

amb 11/10/13

20

✗

Hyd Mech

Memo

Cut blanks at 44.00"

***FOR CLAMPING PURPOSE WHEN WELDING .500" WAS ADDED ON
LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING***

110

0.00



HAAS I

0.00

amb
F.K. 11/10/13

20

✗

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB070 & dwg

FOLIO REV: 3

DWG REV: 3

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74455

Wednesday, October 05, 2011 11:16:10 AM

Page 2

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Start Date: 9/29/2011 Start Qty: 20.00

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Required Date: 10/20/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FOR CLAMPING PURPOSE WHEN WELDING .500" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 1240

0.00



Packaging

Memo

0.00

Packaging

20 11/10/14 20 20 11/14/17 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74455

Wednesday, October 05, 2011 11:16:10 AM



Page 3

Item ID: D3806-5

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Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 9/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/17
ME 11-10-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 11:16:07 AM

Page 1

Work Order ID: 74455

Parent Item: D3806-5

Parent Item Name: Bar



Start Date: 9/29/2011

Required Date: 10/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500 x 2.50		Purchased	No			100	f	13.0870	3.666	77.17895			



304 BAR .500 x 2.50

Location	Loc Qty	Loc Code
MAT050	13.087	
112764	8.312	
116135	0.375	
117685	4.4	

M1119159 X 80' and 11/10/13

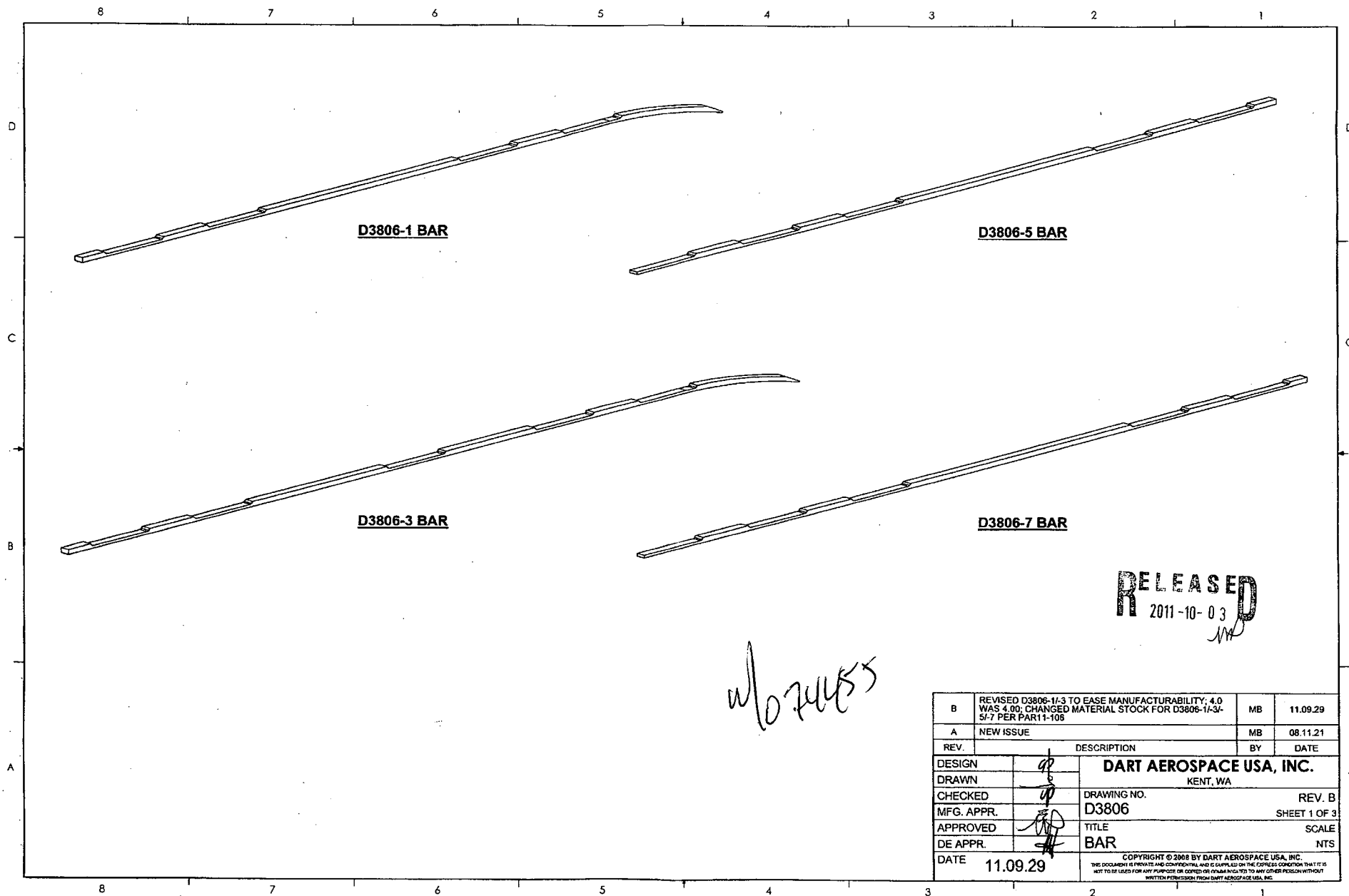
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

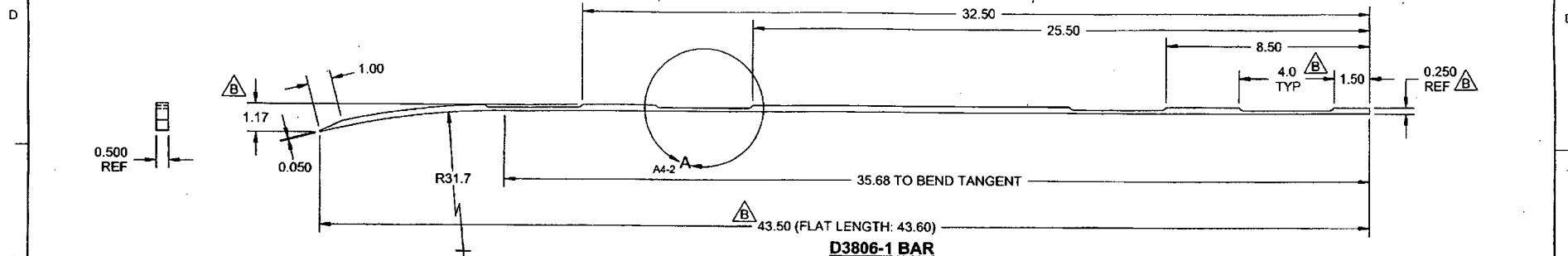
NOTE: Date & initial all entries



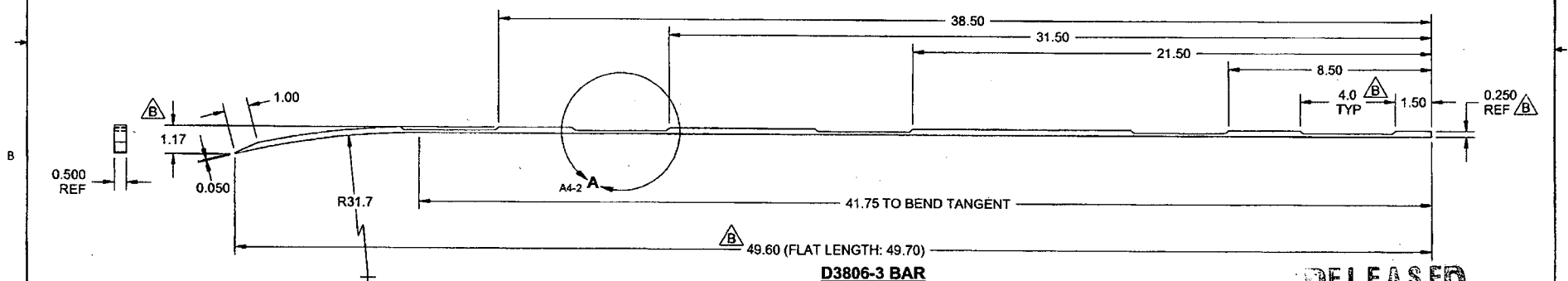
RELEASED
2011-10-03

B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PART 1-106	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>qp</i>	KENT, WA	
CHECKED	<i>qp</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>qp</i>	D3806	SHEET 1 OF 3
APPROVED	<i>qp</i>	TITLE	SCALE
DE APPR.	<i>qp</i>	BAR	NTS
DATE	11.09.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1



D3806-1 BAR

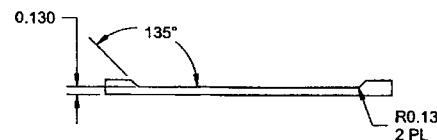


D3806-3 BAR

RELEASED
2011-10-03
JAH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs

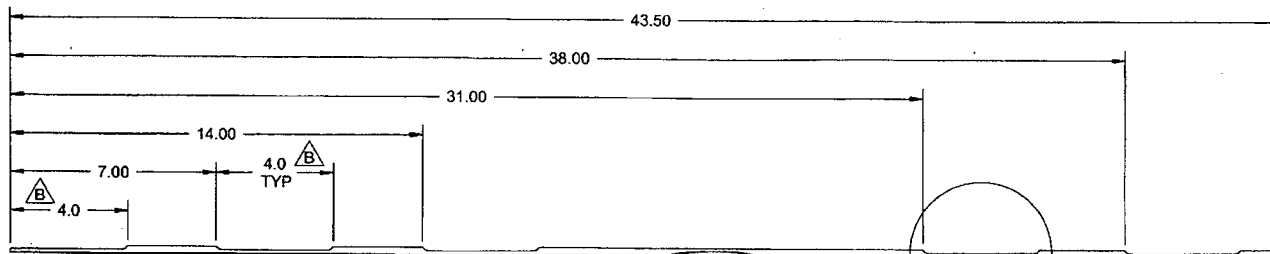
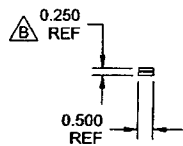


DETAIL A
TYP, SCALE 2X
D5-2
B6-2
C3-3
A3-3

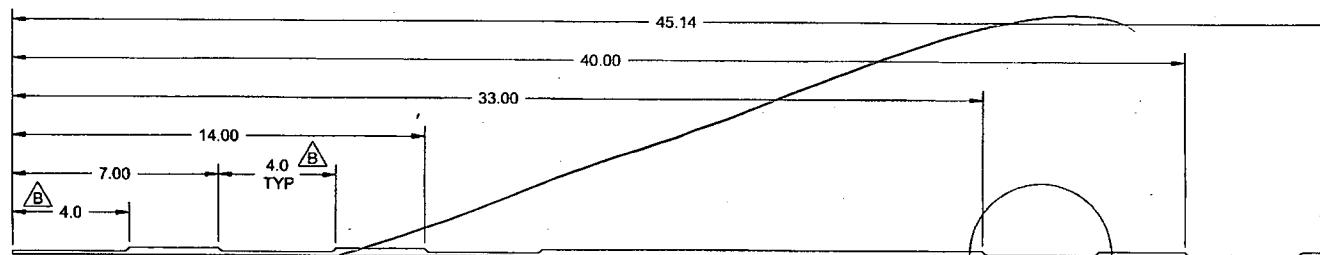
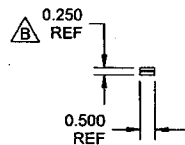
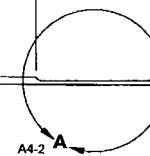
DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>g</i>	KENT, WA	
CHECKED	<i>g</i>	DRAWING NO. D3806	REV. B
MFG. APPR.	<i>g</i>		SHEET 2 OF 3
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	BAR	NTS
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8 7 6 5 4 3 2 1

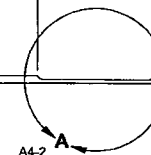
8 7 6 5 4 3 2 1



D3806-5 BAR



D3806-7 BAR



RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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8 7 6 5 4 3 2 1